

WHAT IS CLAIMED IS:

1. A method of die-casting spheroidal graphite cast iron, comprised of the steps of:

preparing a die formed with a heat insulation layer at inside walls of a cavity,

filling molten metal having a composition of the spheroidal graphite cast iron through a runner into said cavity,

closing said runner so as to seal said cavity right before the molten metal in said cavity starts to solidify, and

allowing said molten metal to solidify by the action of the inside pressure caused by crystallization of the spheroidal graphite in said sealed cavity.

2. A method as set forth in claim 1, wherein said heat insulation layer has a heat conductivity of not more than 0.25W/mK and a thickness of not more than 600  $\mu\text{m}$ .

3. A method as set forth in claim 1 or 2, wherein said heat insulation layer is substantially comprised of hollow ceramic particles, solid ceramic particles, and a binder.